

Date: Thursday, 3/23/2006 3:40:13 PM
 User: Kim Johnston

Process Sheet

| | |
|--|---------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : MIRROR BRACKET LH |
| Job Number : 26343 | |
| Estimate Number : 12339 | |
| P.O. Number : N/A | Part Number : D20133 |
| This Issue : 3/23/2006 S.O. No. : N/A | Drawing Number : D2013 REV C |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A Type : SMALL /MED FAB | Drawing Revision : C |
| Previous Run : N/A | Material : N/A |
| Written By : <u>SEE COMMENT BELOW</u> | Due Date : 3/30/2006 Qty: 20 Um: Each |
| Checked & Approved By : <u>FF 06.03.24</u> | |
| Comment : Est Rev:A New Issue 05-11-01 JLM | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----------------|--------------------------|
| 1.0 | M304TR0750W049 | 304 RD Tube .750 x .049W |
|-----|----------------|--------------------------|



Comment: Qty.: 2.0447 f(s)/Unit Total : 40.8933 f(s)
 Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless Tubing
 (M304TR0.750W.049)
 Batch: M100423

20

FF 06.04.03

| | | |
|-----|----------|----------|
| 2.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE

1-Punch as per template D2013-T3 and Dwg D2013

FF 06.04.03

20

2-Flatten ends of D2013-3 tube as per Dwg D2013 using DT8545

FF 06.04.04

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3-Bend (1) tube as per Dwg D2013 using Jig DT8201
Identify as D2013-3.

FF 06.04.04

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4-Deburr as required

FF 06.04.03

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| | | |
|-----|-----|------------------------------|
| 3.0 | QCS | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

06.04.10

20

| | | |
|-----|-------------|-----------------------|
| 4.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS 23

CPC 06.04.13

20

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: Date: 06/04/13
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Thursday, 3/23/2006 3:40:13 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR BRACKET LH

Job Number: 26343

Part Number: D20133

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

DC

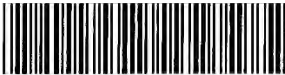
DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

SP 06/04/13 (20)

Job Completion



U 06/04/13

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

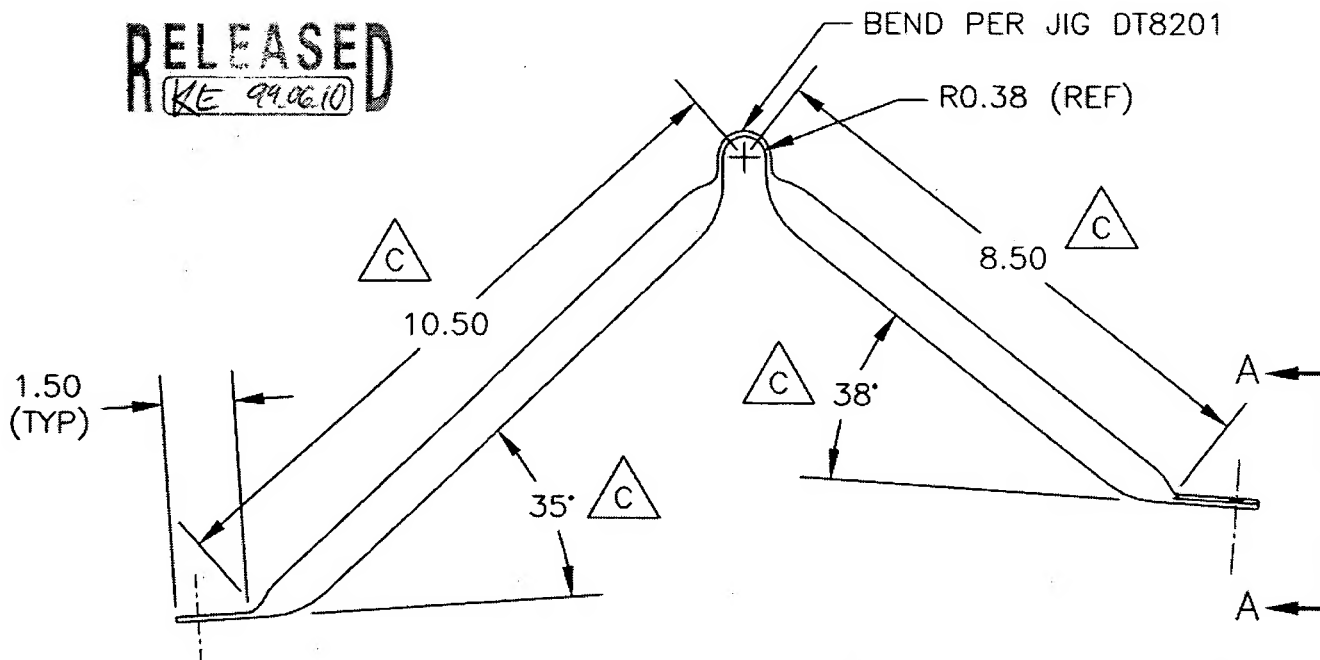
QA: N/C Closed: _____ Date: _____

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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
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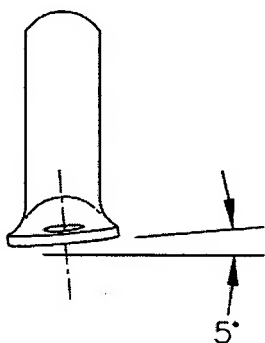
NOTE: Date & initial all entries

RELEASED
(KE 99.06.10)

DART



D2013-1 LH SHOWN
D2013-2 RH OPPOSITE
(FOR 205 MIRROR)



VIEW A-A

DRILL \emptyset 0.257 (TYP)
0.400 (TYP)

CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 OD x 0.049 WALL

| DESIGN | DRAWN BY | DART AEROSPACE LTD |
|------------------|-------------------------|-------------------------------|
| JB | RF | HAWKESBURY, ONTARIO, CANADA |
| CHECKED KE | APPROVED JD | DRAWING NO. D2013 |
| DATE 99.06.07 | TITLE MIRROR BRACKET | REV. C SHEET 1 OF 3 |
| A | 90.10.22 | NEW ISSUE |
| B | 94.06.15 | REDRAWN |
| C | 99.06.07 | REDRAWN, CHANGE OF DIMENSIONS |

Copyright 1990 by DART AEROSPACE LTD

NO. 26343
WORK ORDER
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ENGINEERING
RETURN TO
SHOP COPY

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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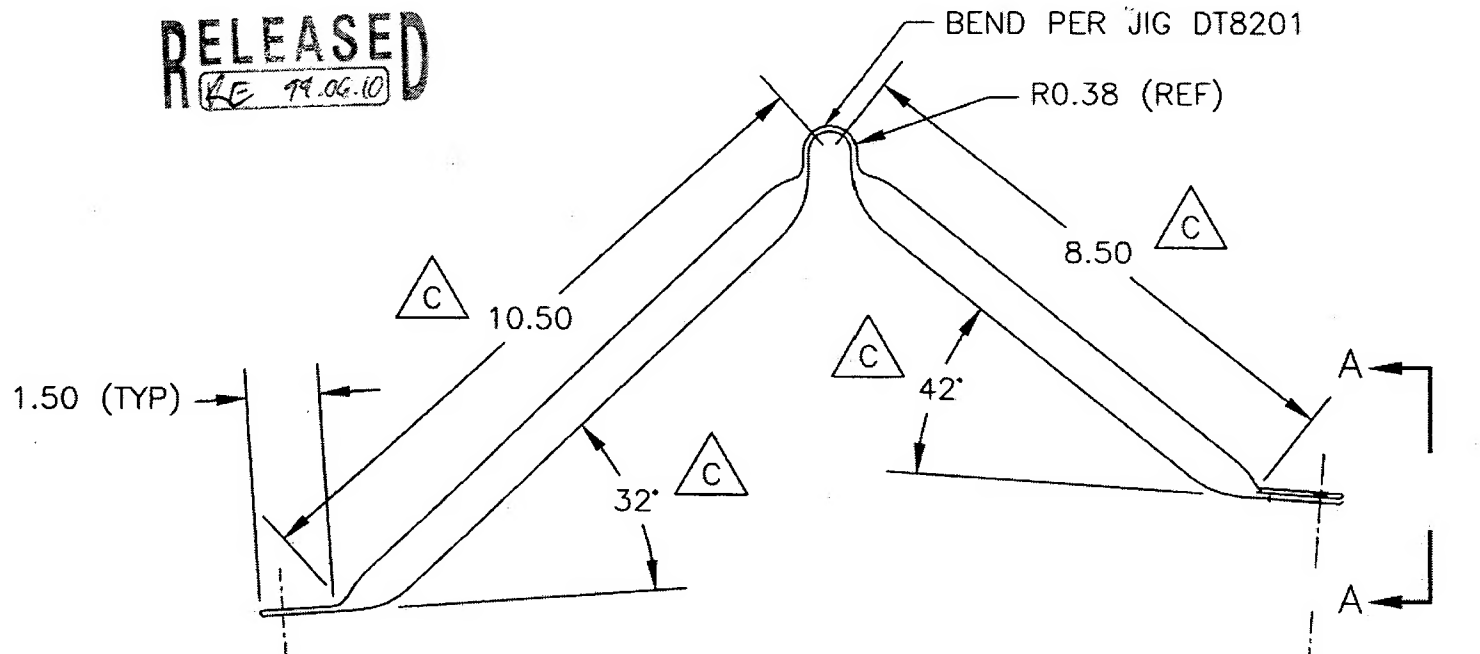
NOTE: Date & initial all entries

RELEASED
RE 99.06.10

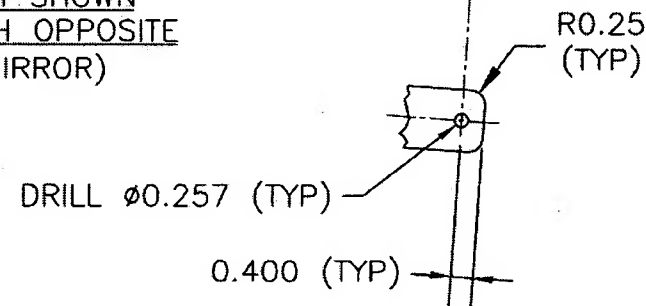
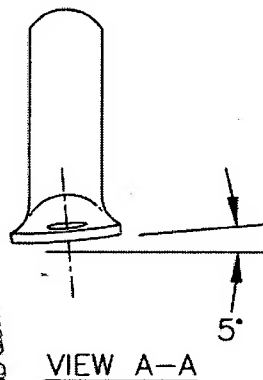
DART



| | | | | | |
|---------|----------|----------|----------------|---|--------|
| DESIGN | JB | DRAWN BY | RF | DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA | |
| CHECKED | KE | APPROVED | [Signature] | DRAWING NO. | D2013 |
| DATE | 99.06.07 | TITLE | MIRROR BRACKET | SHEET 2 OF 3 | REV. C |
| | | | | SCALE | NTS |



D2013-3 LH SHOWN
D2013-4 RH OPPOSITE
(FOR 212 MIRROR)



CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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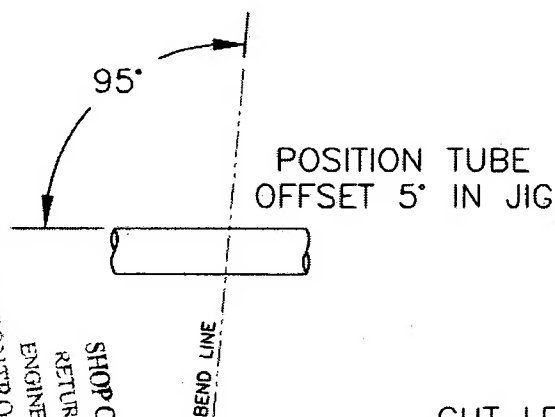
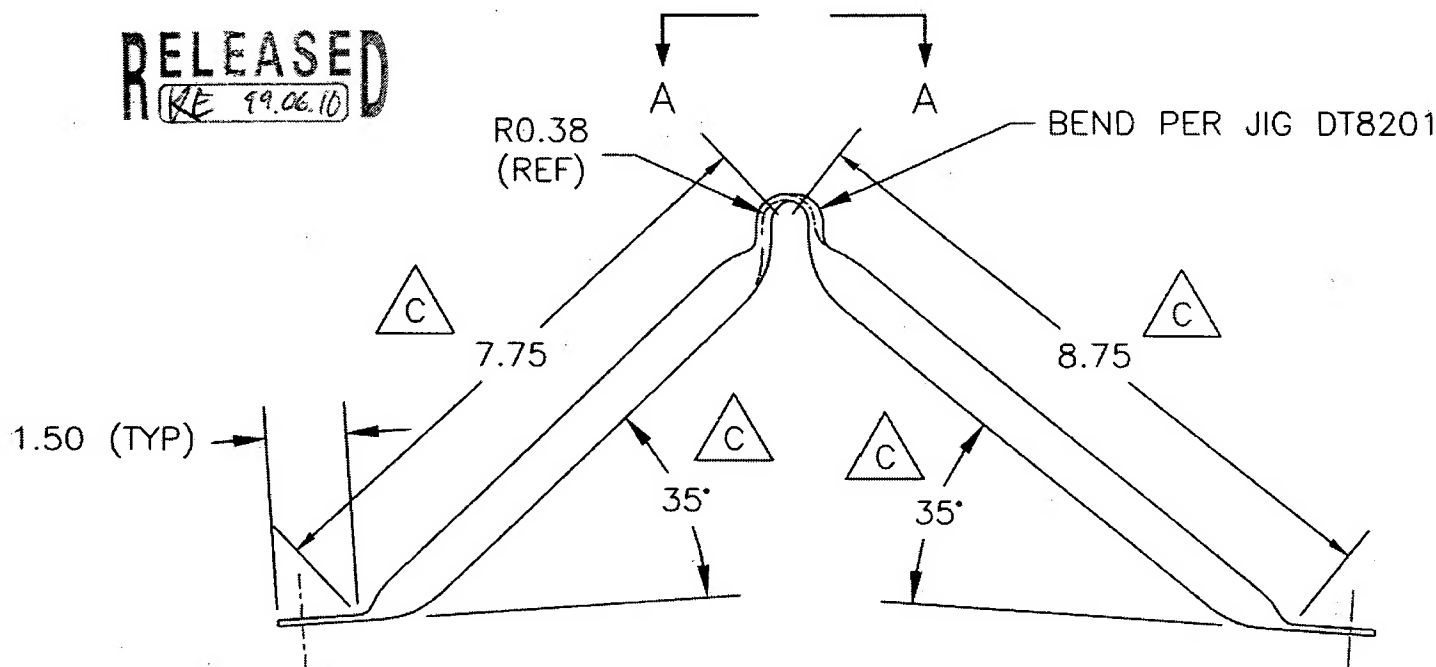
NOTE: Date & initial all entries

RELEASED
(KE 99.06.10)

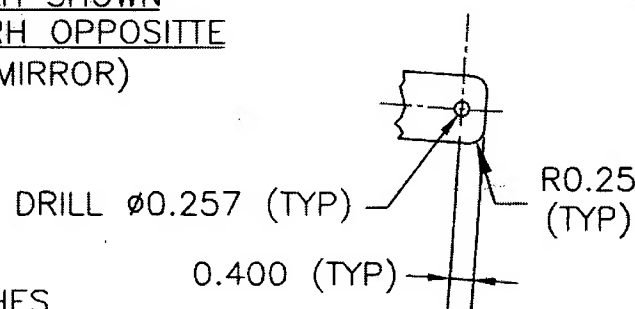
DART



| DESIGN | JB | DRAWN BY | DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA | REV. C |
|---------|----------|----------|---|--------------|
| CHECKED | KE | APPROVED | DRAWING NO. D2013 | SHEET 3 OF 3 |
| DATE | 99.06.07 | TITLE | MIRROR BRACKET | SCALE |
| | | | | NIS |



D2013-5 LH SHOWN
D2013-6 RH OPPOSITE
(FOR 204 MIRROR)



CUT LENGTH: 20.75 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

VIEW A-A

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Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries